

Work Order ID 148823

July 08, 2016 11:54:59 AM

148823

Page 1

Item ID: PB67-43001-13

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 7/8/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 8/3/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: SK Date: 7/8/16 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-13	Rev C								

100

0.00

100

Large Fab

Large Fab

Memo

0.25

Large Fab

1- make a 0.090" chamfer in the 1.00" hole before welding

2- grind weld flush in area of PB67-43001-249 only

AL ROD A/R

BATCH: 134826

3 JUL 12 2016 **DAS**
24
9-89

102

0.00

102

Mill Conv

Memo

0.25

Conventional Milling Machine

DRILL AND TAP FOR 1/2"-20 HELICAL INSERT

INSTALL HELICAL INSERT

3 Ø **DAS**
32
9-89
16-01-t3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

Work Order ID 148823

July 08, 2016 11:54:59 AM

Item ID: PB67-43001-13
Revision ID:
Item Name: Aft Adjustable Blade Support Assembly
Start Date: 7/8/2016 Start Qty: 3.00
Required Date: 8/3/2016 Req'd Qty: 3.00
Reference:

Approvals: Process Plan: Date:
QC: Date:

Sequence ID/ Work Center ID	Operation Description
190 *190* QC Quality Control	QC5- Inspect part completeness to step on Memo
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: Memo
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Rel Memo

Work Order ID 148823

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Page 3

Item ID: PB67-43001-13
Revision ID:
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Start Date: 7/8/2016 Start Qty: 3.00
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Reference:

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***

Cust Item ID:
Customer:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per OSI005 4.3 <i>M134.092</i> Memo 1- MASK TUBE FROM BASE TO GUSSET START TIME: <i>2:35</i> OVEN TEMPERATURE: <i>800</i> FINISH TIME: <i>3:05</i>	0.00 0.08				3	0	1607-20	DAS 34 9-89
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				3			DAS 38 9-89 JUL 21 2016
180 *180* Small Fab Small Fab	Small Fab Memo 1- match drill cover to existing holes in support 2- assemble as per dwg	0.00 0.20				3	0	16-07-25	

DQA: _____ Date: _____

WORK ORDER

QA Closed: _____ Date: _____

Work Order: _____	DISP
Part No. _____	
NCR No. _____	

Date : _____	Step #: _____
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Description Work Order Deviation

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Root Cause		
Environment ☐	No Re-verification ☐	Pressure/Force ☐
Design ☐	Operator ☐	Bending ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Con ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Rip ☐
Material ☐	Use for Testing ☐	Cuffs ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐
LOA ☐	Product Improvement ☐	Wave/Twist in ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐
Past Expiry Date ☐	Manufacturing Process ☐	
Misidentified ☐	Past Due ☐	OTHER : ☐

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐

Date : _____	Step #: _____	QTY Effective : _____	MRB (QS1042) Approval ☐
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Description Work Order Deviation	Disposition	Completed By
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Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : ☐			

Picklist Print

July 08, 2016 11:54:58 AM

Page 1

Work Order ID: 148823

148823

Parent Item: PB67-43001-13

PB67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.27 per RevC EC verified by:DD

IPP RevC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-67		Manufactured	No				Each	4.0000		3			DAS
PR67-43001-67									**			JUL 12 2016	24 9-89

90° Blade Support Assembly

Location	Loc Qty	Loc Code
Mezz2	1	
111266	1	
WA004	3	
139184	3	

PB67-43001-249

Manufactured No

PR67-43001-249

Inner Tube Bushing

Location	Loc Qty	Loc Code
WA003	14	
133726	14	

PB67-43001-253

Manufactured No

PR67-43001-253

Gusset

Location	Loc Qty	Loc Code
Mezz2	13	
116441	1	
139182	12	

**

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3	3	JUL 12 2016	DAS 24 9-89
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3	3	JUL 12 2016	DAS 24 9-89
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3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Picklist Print

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Work Order ID: 148823

148823

Parent Item: PB67-43001-13

PR67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-254 Manufactured No

100 Each 9.0000 1 3

PR67-43001-254

**

JUL 12 2016

DAS
24
9-89

Gusset

Location Loc Qty Loc Code

Mezz2 9

133227 1

139181 8

PB67-43001-255 Manufactured No

100 Each 3.0000 1 3

PR67-43001-255

**

JUL 12 2016

DAS
24
9-89

Inner Tube

Location Loc Qty Loc Code

Mezz2 3

139185 3

MS124780 Purchased No

180 Each 35.0000 1 3

MS124780

**

16-07-13

DAS
32
9-89

HELICAL INSERT

Location Loc Qty Loc Code

ST260a 19

m128173 19

ST316 16

111064 16

MS27039-1-10 Purchased No

180 Each 284.0000 8 24

MS27039-1-10

**

SCREW

Location Loc Qty Loc Code

CA 31

m128635 31

GA 14

m129541 14

ST280 239

m134676 239

DAS
6
9-89

DAS
6
9-89

JUL 21 2016

July 08, 2016 11:54:58 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																									
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Parent Item: PB67-43001-13

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Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

NAS1149D0316J

Purchased

No

180

Each

1,624.000

8

24

NAS1149D0316J

Washer

**

DAS

8

9-89

Location

Loc Qty

Loc Code

ST264

1624

M134502

1624

NAS1149D0363J

Purchased

No

180

Each

1,744.000

8

24

NAS1149D0363J

Washer

**

DAS

8

9-89

Location

Loc Qty

Loc Code

GA

418

m134055

418

ST263

1326

m134676

326

m134955

1000

PB67-43001-69

Manufactured

No

180

Each

6.0000

1

3

PB67-43001-69

90 Degree Cover Plate

**

JUL 28 2016

DAS

24

9-89

Location

Loc Qty

Loc Code

Mezz2

6

138691

6

PB67-43001-83

Manufactured

No

180

Each

21.0000

1

3

PB67-43001-83

D-Pad Assembly, Short

**

JUL 28 2016

DAS

24

9-89

Location

Loc Qty

Loc Code

Mezz2

21

138687

21

DQA: _____ Date: _____

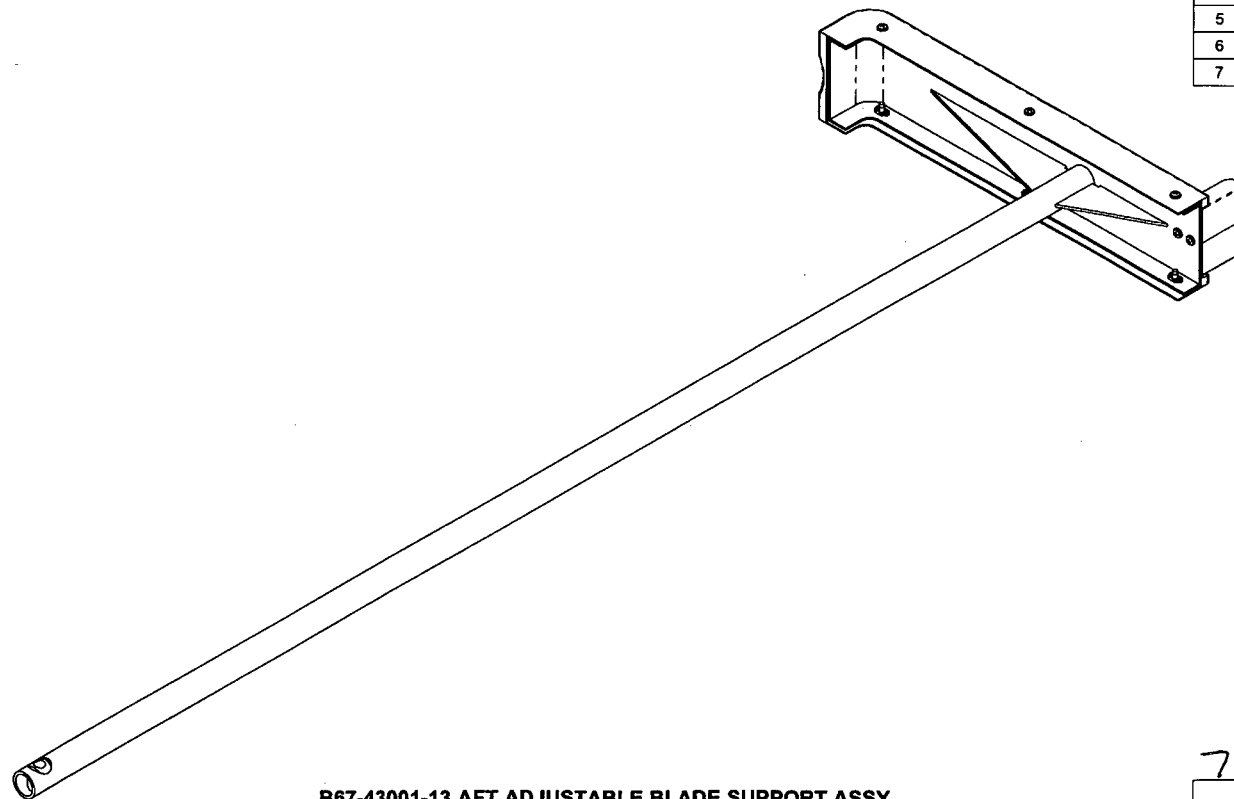


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														



B67-43001-13 AFT ADJUSTABLE BLADE SUPPORT ASSY

ITEM	QTY -13	P/N	DESCRIPTION
1	X	B67-43001-13	AFT ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-13W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-69	90° COVER PLATE ASSEMBLY
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

RELEASED
2010-09-16
MM

7/8/16 SH 148823

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION			BY	DATE
DESIGN	RW			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-13 TITLE AFT ADJUSTABLE BLADE SUPPORT ASSY SCALE NTS DATE 10.04.28	
DRAWN	5				
CHECKED	JP				
MFG. APPR.	AW				
APPROVED	N/A				
DE APPR.	N/A			REV. C SHEET 1 OF 2	

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